

Work Order ID 105855

August-22-13 10:57:47 AM

105855

Page 1

Item ID: D412-742-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube (Fits LH or RH) High Gear Apical & OEM Cylindrical Float Compatible

Start Date: 8/22/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/05/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MCS Date: 13-08-22 Tooling: _____ Date: _____Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3391	I								

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

If D412-742-041 is a W/O on it's own,
Photocopy bluefile and create labels per PPP D412-742-041 CHG005

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Item ID: D412-742-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Replacement Skidtube (Fits LH or RH) High Gear Apical & OEM Cylindrical Float Compatible
 Start Date: 8/22/13 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 9/05/13 Req'd Qty: 1.00 ***1*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Assemble as per dwg HandFinishing	0.00				1x	1	11	13/08/23
110	HandFinish	0.00							
Hand Finishing	Memo 1-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins. A/RSikaflex-241/-291 <u>M126410</u> Expiry date: <u>14105</u> 2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Seal all bolts with sikaflex except ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex. A/RSikaflex-241/-291 <u>M126410</u> Expiry date: <u>14105</u> 3-Remove "T" pins once sikaflex is dry. 4-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser. A/RLPS Procyon <u>M122900</u>								
120	QC5- Inspect part completeness to step on W/O	0.00							
120	QC	0.00							
Quality Control	Memo								

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-742-041								
	Location: _____								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

13/9/16
DAS
06
9-89PPP
105905

MLJ 13-09-18

11/13-09-18

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D412-742-041

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

833

** ¹ B91902(1v) ¹ Hl 13108122

** 13104691(IV) 13108/22

1 1
 ** 1387598(1x) ll 13/08/22
 24 24
 ** ll 13/08/22 (pulled 01-013)

Picklist Print

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Work Order ID: 105855

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Parent Item: D412-742-041

D412-742-041

Parent Item Name: Replacement Skidtube (Fits LH or RH) High Gear Apical & OEM Cylindrical Float Compatible

Start Date: 8/22/13

Required Date: 9/05/13

AN3C6A

Purchased

No

110

Each

1,013.000

Start Qty: 1.00

10

10

Required Qty: 1.00

AN3C6A

Bolt

**

13/08/27

Location

Loc Qty

Loc Code

FG

10

122416

10

FP001

30

122599

30

FP002

1

111982

1

ST351

17

122416

17

ST512

955

m125709

955

110

AN3C7A

Purchased

No

110

Each

1,017.000

4

4

AN3C7A

Bolt

**

13/08/27

Location

Loc Qty

Loc Code

FG

10

122141

10

FP001

1

122800

1

ST351

16

123900

6

124221

10

ST511

990

m125709

990

12

12

AN960C10L

NAS1149C0332

Purchased

No

110

Each

0.0000

38

38

***AN960C10I *✓**

Washer

**

11125654 (x38) 13/08/27

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Shop Packet Print

Picklist Print

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Parent Item: D412-742-041

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Parent Item Name: Replacement Skidtube (Fits LH or RH) High Gear Apical & OEM Cylindrical Float Compatible

Start Date: 8/22/13

Required Date: 9/05/13

MS27039C4-12

Purchased

No

110

Each

Start Qty: 1.00
201.0000 4 4

Required Qty: 1.00

MS27039C4-12

SCREW

**

11 13/08/22

Location

Loc Qty

Loc Code

ST308

1

M122452

x4

114221

1

ST309

200

124586

200

D3672-3

Manufactured

No

110

Each

1,520.000 4 4

D3672-3

Phenolic Washer

**

11 13/08/27

Location

Loc Qty

Loc Code

FG

111

84432

11

89273

100

FP-001

107

91915

107

ST061

711

84432

32

86517

5

88441

25

91915

140

93925

509

ST062

591

101707

91

102961

500

AN960C416L

NAS1149C0432

Purchased

No

110

Each

0.0000 4 4

***AN960C416L ***

Washer

**

11 12/24/11 (1x) 11 14/08/22

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Picklist Print

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Parent Item: D412-742-041

D412-742-041

Parent Item Name: Replacement Skidtube (Fits LH or RH) High Gear Apical & OEM Cylindrical Float Compatible

Start Date: 8/22/13

Required Date: 9/05/13

D4095-041 Manufactured No 110 Each 7.0000 Start Qty: 1.00 Required Qty: 1.00
D4095-041 ** 1 1
Wearplate Assembly 13/08/27

Location Loc Qty Loc Code

FP002 7
102481 7

D4095-043 Manufactured No 110 Each 5.0000 Start Qty: 1.00 Required Qty: 1.00
D4095-043 ** 1 1
Wearplate Assembly 13/08/27

Location Loc Qty Loc Code

FP002 5
101677 4
96194 1

D4095-045 Manufactured No 110 Each 14.0000 Start Qty: 1.00 Required Qty: 1.00
D4095-045 ** 1 1
Wearplate Assembly 13/08/27

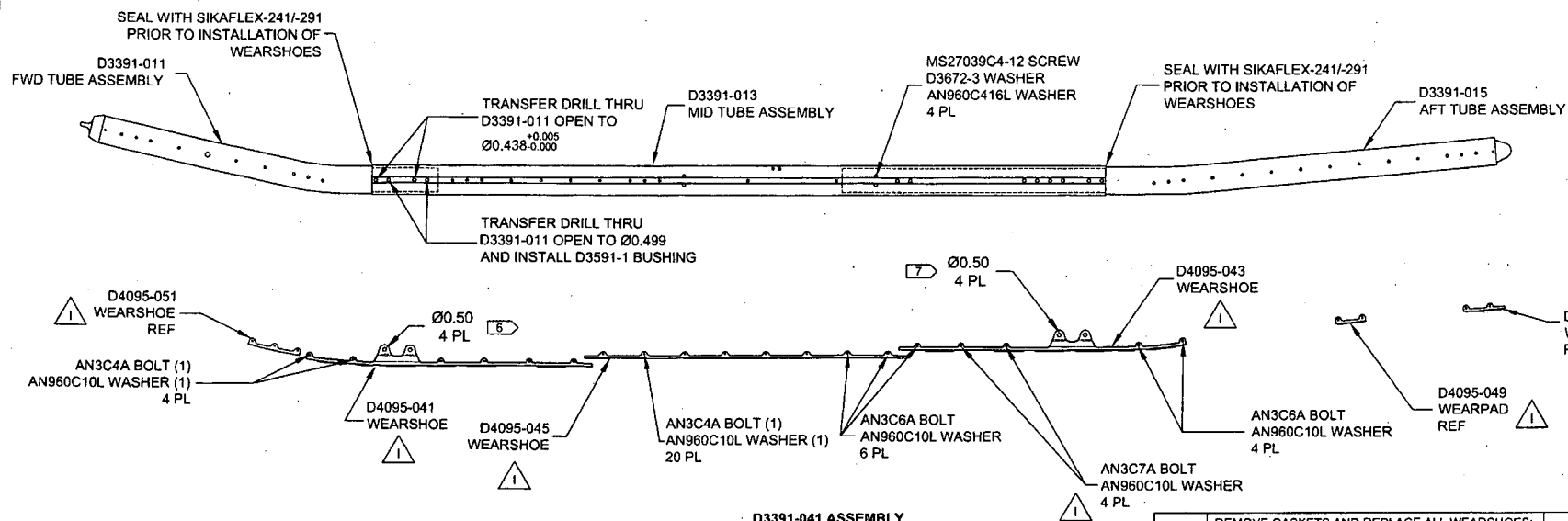
Location Loc Qty Loc Code

FP 1
100835 1
FP002 13
102391 9
77737 1
84081 1
93054 2

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Shop Packet Print

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D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
4	D3672-3	WASHER
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARSHOE
1	D4095-049	WEARSHOE
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON"
AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT
WHERE INDICATED.
- 6) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH
APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND
TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 7) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH
THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND
TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

RELEASED
2011-11-04
ECN# 11-662

I	REMOVE GASKETS AND REPLACE ALL WEARSHOES; PARTS LIST UPDATE, ZN A8-1, ZN A8-2, ZN A6-4, ZN B6-8; LPS-3 COATING REMOVED FROM NOTE 2, ZN A3-1, ZN A3-2, REMOVED INSERT AELS-1032-130, ZN B6-4, B2-4, C7-8, C3-8; REMOVED HOLES, ZN D6-4 ZN D2-4, ZN D7-8, ZN D3-8	XDF	11.10.13
H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING, ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING, ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.16
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO.	REV. 1
MFG. APPR.		D3391	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	11.10.13	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC	
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UNCONTROLLED
105855 MWS
13-08-22